

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021167**Date Inspected:** 27-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** LV Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

Bay 14/OBG 14E Assy

Flux Core Arc Welding (FCAW) in the 2G position of Vertical Plate PL3467A 'I' rib weld # VP3016-001-013. The welder is identified as 066763. ZPMC CWI is identified as LV Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U4b-F. See attached photograph Pic\_001.

Bay 14/OBG 13CW Assy

Sub Arc Welding (SAW) in the 1G position of Deck Panel plate PL3146A to PL3147A weld # SEG3015-003. The welder is identified as 045270. ZPMC Quality Control (QC) is identified as Xia Chun Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

OBG Segment 11CE – Blast shop 1

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## WELDING INSPECTION REPORT

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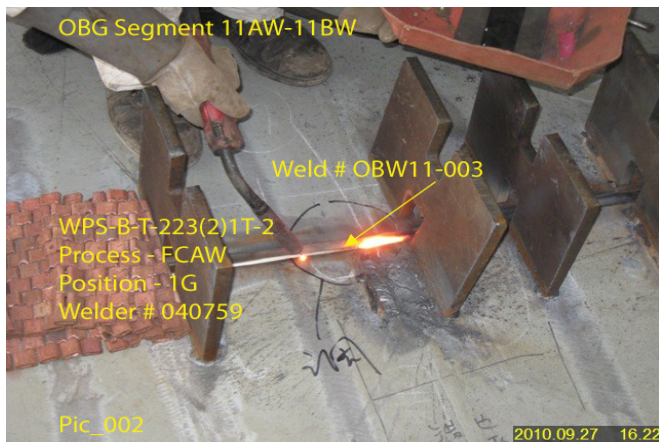
This QA inspector performed internal Visual Inspection of OBG Segment 11CE after Blasting in ZPMC Blast Shop # 1.

Bay 14/OBG 13BW Assy

Sub Arc Welding (SAW) in the 1G position of Deck Panel DP3134A to DP3135A weld # SEG3014-004. The welder is identified as 045270. ZPMC Quality Control (QC) is identified as Xia Chun Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

OBG Segment 11AW-11BW

Flux Core Arc Welding (FCAW) in the 1G position of Deck Panel splice weld # OBW11-003. The welder is identified as 040759. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2. See attached photograph Pic\_002.



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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